

Work Order ID 78352

78352

Page 1

Thursday, January 05, 2012 3:22:15 PM

Item ID: D4006-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Tank Top Support Assembly

Stop ***NS2***

Start Date: 1/6/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 12-01-06

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4006

A

100

0.00

100

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D4006

Signature 12/01/10 (E)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

Signature 12/01/10

(44)

120

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

Start Time:

Oven Temperature:

Finish Time:

3:50
320°F
4:20

Signature 12/01/10

m 118489

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78352

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Page 2

Thursday, January 05, 2012 3:22:16 PM

Item ID: D4006-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Tank Top Support Assembly
 Start Date: 1/6/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Apply glue and install Foam as per dwg Batch: <u>1119597</u> 2- Install anchor nuts as per dwg	3M 1300 countact cement							
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

4 PL 121-11

12/01/11 (4)

(x4)

8/2/04/12

W/O:		WORK ORDER CHANGES					
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 Item Name: Tank Top Support Assembly
 Start Date: 1/6/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <i>ST 107</i>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

(4X) Sp 12-01-12.

12/1/16
ME
12-01-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 05, 2012 3:22:15 PM

Page 1

Work Order ID: 78352

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 09.12.18 new issie Prelim EC verified by:DD
562 DD verified by:EC
IPP Rev:C 10.07.12 added type of glue DD verf:JLM
IPP Rev:B 10.05.03 as per ECN10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4006-1 Angle		Manufactured	No			100	Each	8.0000	1	4		1/2/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
				70187		8							
D4006-3 Channel		Manufactured	No			100	Each	10.0000	2	8		1/2/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST107		10							
				72752		10							
MS20470AD4-5 Rivet, Universal Head		Purchased	No			100	Each	1,706.0000	8	32		1/2/10	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		1706							
				118405		1706							
D4006-5 Foam		Manufactured	No			140	Each	4.0000	1	4		1/2/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST106		4							
				63940		4							
MS20426AD3-4 RIVET		Purchased	No			140	Each	4,380.0000	4	16		1/2/11	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST316		4380							
				104374		1076							
				110398		3304							

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Picklist Print

Thursday, January 05, 2012 3:22:15 PM

Page 2

Work Order ID: 78352

Parent Item: D4006-041

Parent Item Name: Tank Top Support Assembly

Start Date: 1/6/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

MS21059L4

Purchased

No

140

Each

73.0000

2

8

Nutplate

Location

Loc Qty

Loc Code

ST301

73

117887

3

118612

20

119623

50

8 5/2/07/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

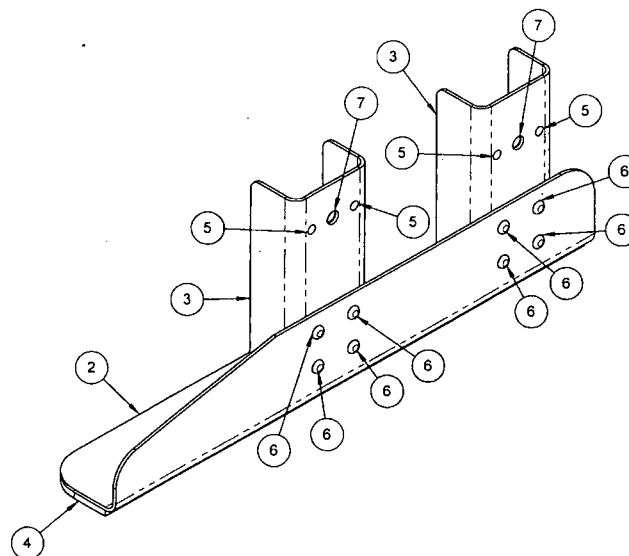
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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

A	NEW ISSUE	BY	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4006	REV. A
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#78352

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2010-05-05
MD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

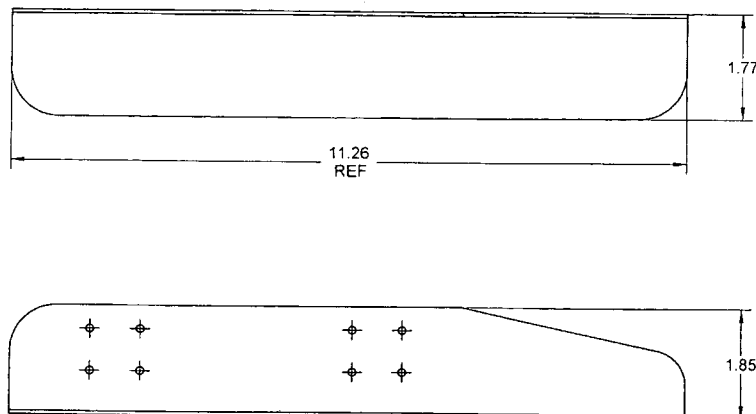
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

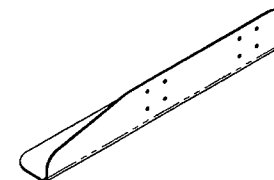
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

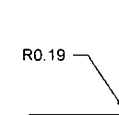
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-1	REF JCA-M47-2-01



D4006-1 ANGLE



78352



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2010-05-05
MP

NOTES:

- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

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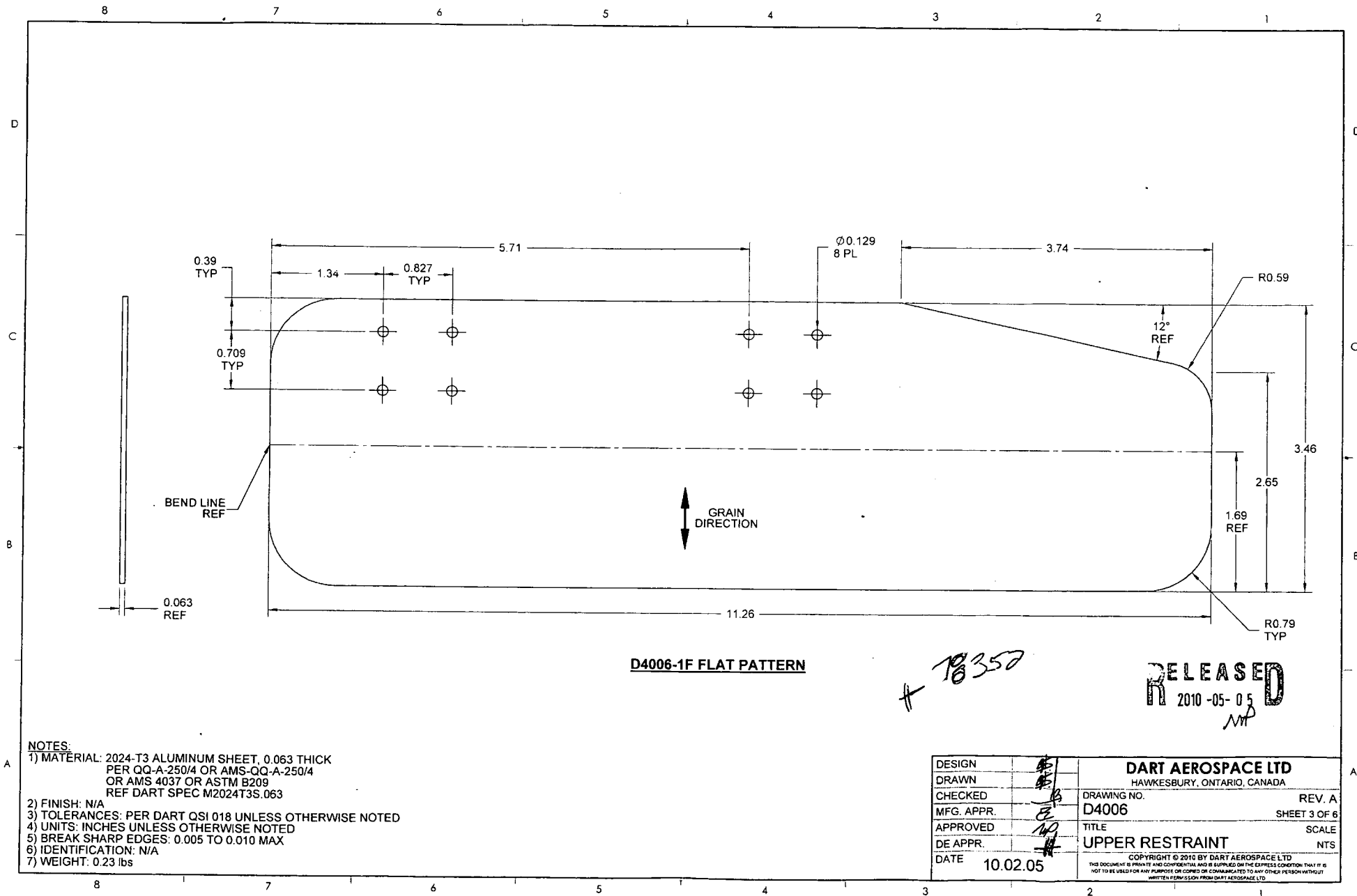
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.23 lbs

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MFG. APPR.		D4006	SHEET 3 OF 6
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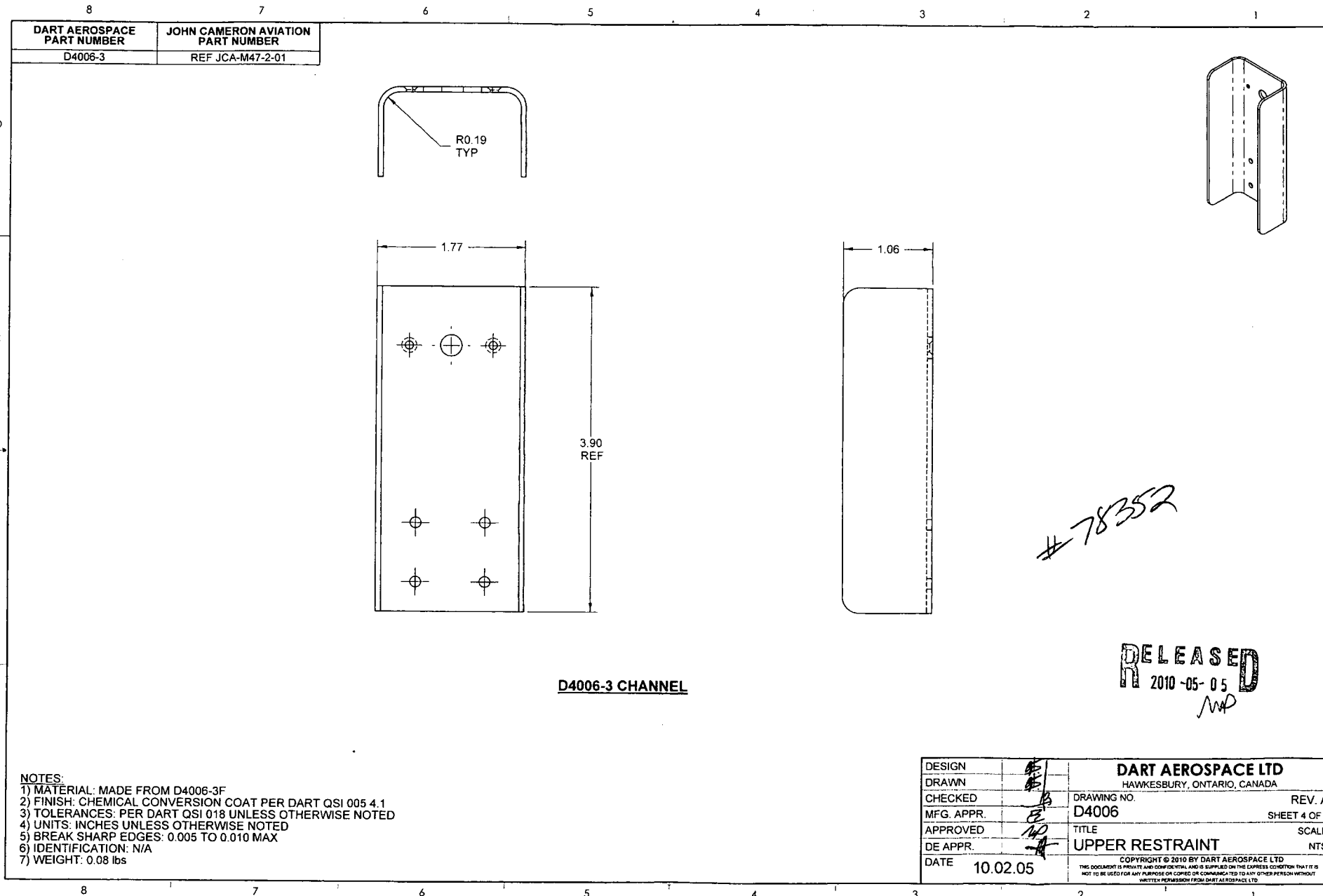
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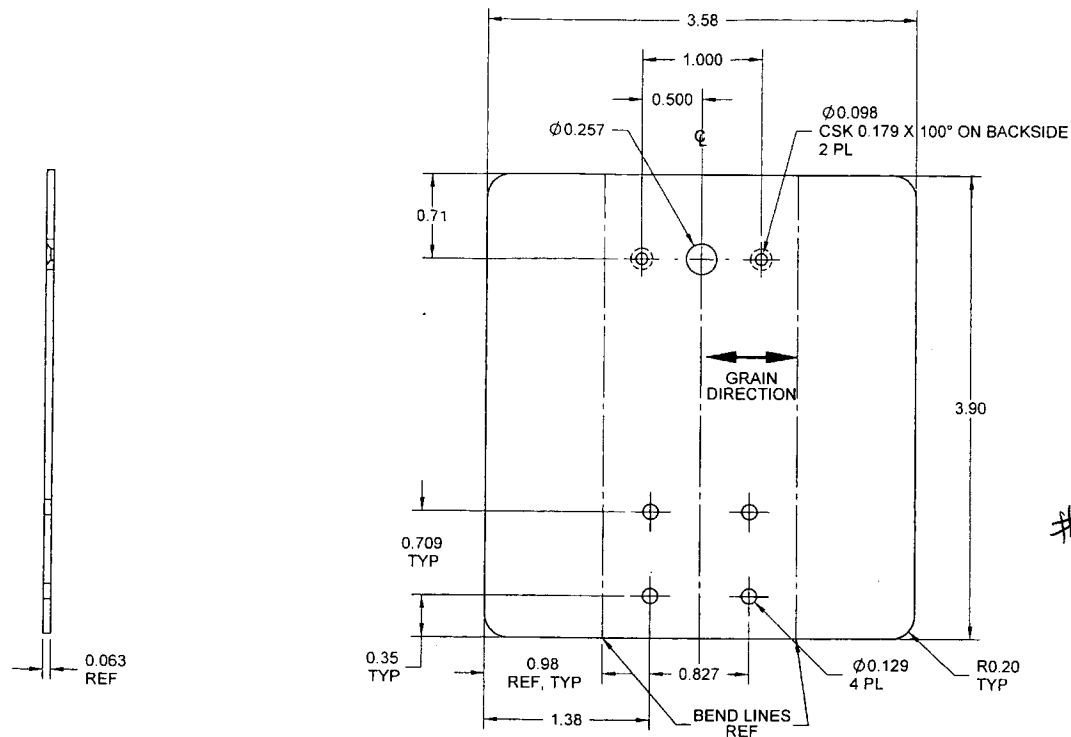
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NOTE: Date & initial all entries



D4006-3F FLAT PATTERN

78352

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2010-05-05
md

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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MFG. APPR.		D4006	SHEET 5 OF 6
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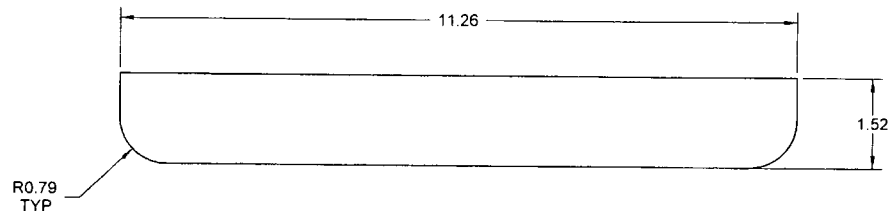
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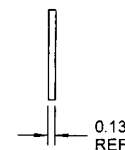
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



D4006-5 FOAM









#78352

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NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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